

Amendment to the Claims

1. (Currently Amended) A method for working a tube comprising:

inserting a mandrel into a blank tube in a form of a welded tube:

applying a parallel swaging operation by translating a ~~non-formable~~ cylindrical die axially along and relative to the blank tube and the mandrel so as to cause the blank tube to contact tightly with the mandrel;

subsequently withdrawing the cylindrical die from the blank tube, while keeping the mandrel in the blank tube; and

moving a push-die to the blank tube from a radially outward position to flatten a weld portion on the blank tube in cooperation with the mandrel.

2. (Cancelled)

3. (Previously Presented) A method for working a tube in accordance with claim 1, wherein a tapered surface is formed at an inner edge of a tip end of the blank tube through a cooperative action between the mandrel and the cylindrical die.

4. (Previously Presented) A method for working a tube in accordance with claim 1, wherein a reduced thickness portion is formed at a tip end of the blank tube through a cooperative action between the mandrel and the cylindrical die, so that the reduced thickness portion can be used as a bent piece extending in a radially inward direction.

5. (Previously Presented) A method of working a tube in accordance with Claim 3, wherein a reduced thickness portion is formed at the tip end of the blank tube through a cooperative action between the mandrel and the cylindrical die so that the reduced thickness portion can be used as a bent piece extending in a radially inward direction.

6. (Currently Amended) A method for working a tube in accordance with Claim 1, wherein a relief portion is formed in an inner surface of the cylindrical die at an inner portion that is spaced from an open end of the cylindrical die to extend circumferentially, and the relief portion has a slightly enlarged inner diameter and is used as a reservoir for lubricating oil.

7. (Cancelled)

8. (Previously Presented) A method for working a tube in accordance with Claim 3, wherein a relief portion is formed in an inner surface of the cylindrical die at an inner portion that is spaced from an open end of the cylindrical die to extend circumferentially, and the relief portion has a slightly enlarged inner diameter and is used as a reservoir for lubricating oil.

9. (Previously Presented) A method for working a tube in accordance with Claim 4, wherein a relief portion is formed in an inner surface of the cylindrical die at an inner portion that is spaced from an open end of the cylindrical die to extend circumferentially, and the relief portion has a slightly enlarged inner diameter and is used as a reservoir for lubricating oil.

10. (Previously Presented) A method for working a tube in accordance with Claim 5, wherein a relief portion is formed in an inner surface of the cylindrical die at an inner portion that is spaced from an open end of the cylindrical die to extend circumferentially, and the relief portion has a slightly enlarged inner diameter and is used as a reservoir for lubricating oil.

11. (Currently Amended) An apparatus for working a tube, said apparatus comprising a parallel swaging machine and a push-die, said parallel swaging machine including a clamp for supporting a blank tube, a mandrel insertable into the blank tube when supported on the clamp, and ~~a non-formable~~ a cylindrical die that translates along the blank tube when supported on said clamp, said push-die being mounted on said parallel swaging machine so that it moves toward the blank tube from a radially outward position and away from the blank tube.

12. (Previously Presented) An apparatus for working a tube in accordance with Claim 11, wherein a forming surface is provided on said mandrel for forming a tip end of the blank tube to have a thickness that is less than an adjacent wall portion of the blank tube.

13. (New) A method for working a tube comprising:
inserting a mandrel into a blank tube in a form of a welded tube having a weld bead;
orienting the blank tube so that the weld bead is positioned in a stroke of a push-die;
applying a parallel swaging operation by translating a cylindrical die axially along and

relative to the blank tube and the mandrel so as to cause the blank tube to contact tightly with the mandrel;

subsequently withdrawing the cylindrical die from the blank tube; and

moving the push-die to the blank tube from a radially outward position to flatten a weld portion on the blank tube.